

Date: Wednesday, 12/21/2005 8:01:31 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER
<b>Job Number</b> : 25339	
<b>Estimate Number</b> : 11169	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D32831
<b>This Issue</b> : 12/21/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3283 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : See comment below	<b>Due Date</b> : 12/28/2005 <b>Qty:</b> 50 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : See comment below	
<b>Comment</b> : Est A. 04.09.28 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S063	6061-T6 .063 Sheet
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**Comment:** Qty.: 0.2479 sf(s)/Unit Total : 12.3953 sf(s)  
 6061-T6 .063 Sheet  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
 (M6061T6S.063)  
 Identify for D3283-1  
 Batch: M19326

SD 05.12.21 +10  
 En 05/12/21 50

2.0	SHEAR	SHEAR
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**Comment:** SHEAR 13.000  
 Cut blanks: 15.550" x 2.000" 1.540.

SD 05.12.21 +10  
 En 05/12/21 50

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA424 and Dwg D3283  
 Stack of 10  
 Identify as D3283-1

J.L 05.12.21 50

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05.12.21 50

5.0	QC8	SECOND CHECK
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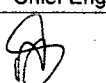


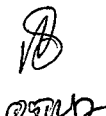
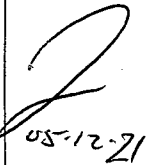


**Comment:** SECOND CHECK

gml 05/12/21 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.12.21	3	- 1 stack of 10 scrap - error in pgm drilled only 4 1/2 holes instead of 5	 J.L.	- scrap + replace - pgm fixed	 J.L.	 05.12.21	 05.12.21	 05.12.21

NOTE: Date & initial all entries

Date: Wednesday, 12/21/2005 8:01:31 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25339

Part Number: D32831

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

FF 05/12/22

50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

u

05-12-22

50

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST

06-01-04

50

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

SUR 06/01/05

(50)

06/01/05

Job Completion



Get FP Alod Etek + Alodine

FF 05/12/22

50

50

# Dart Aerospace Ltd

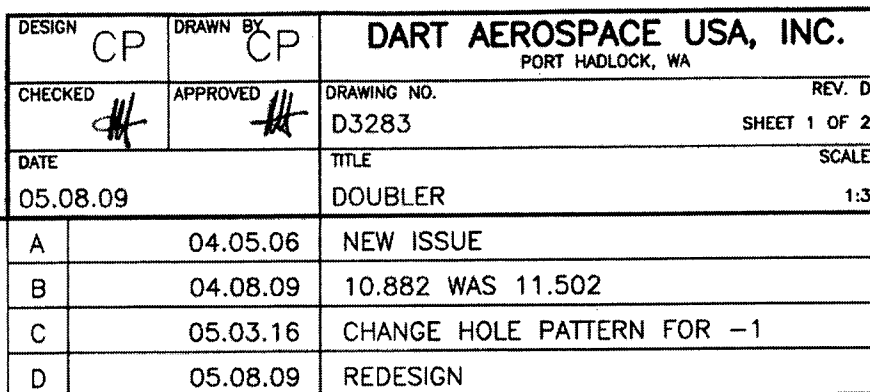
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05/12/22	6	Permanent change	U	05/12/22		U	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

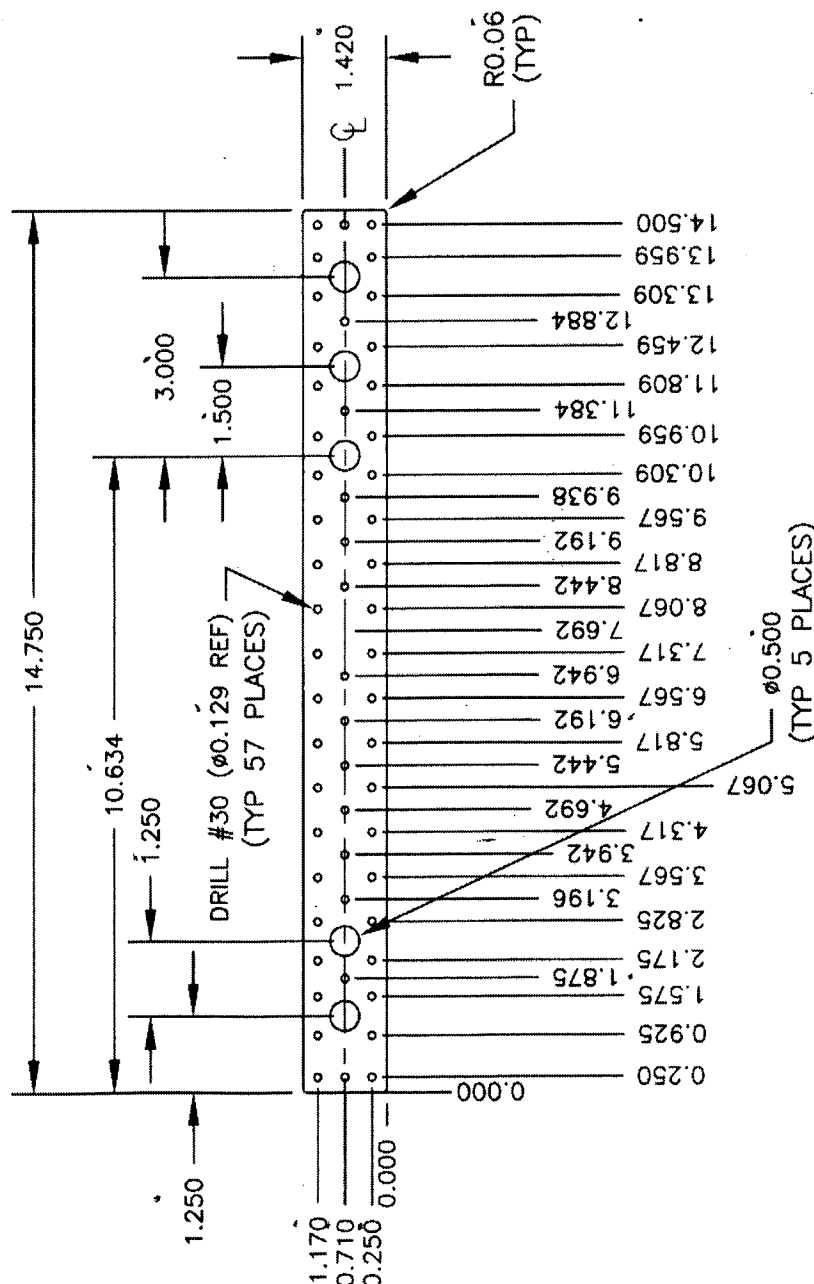
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



05-29-06 #



1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

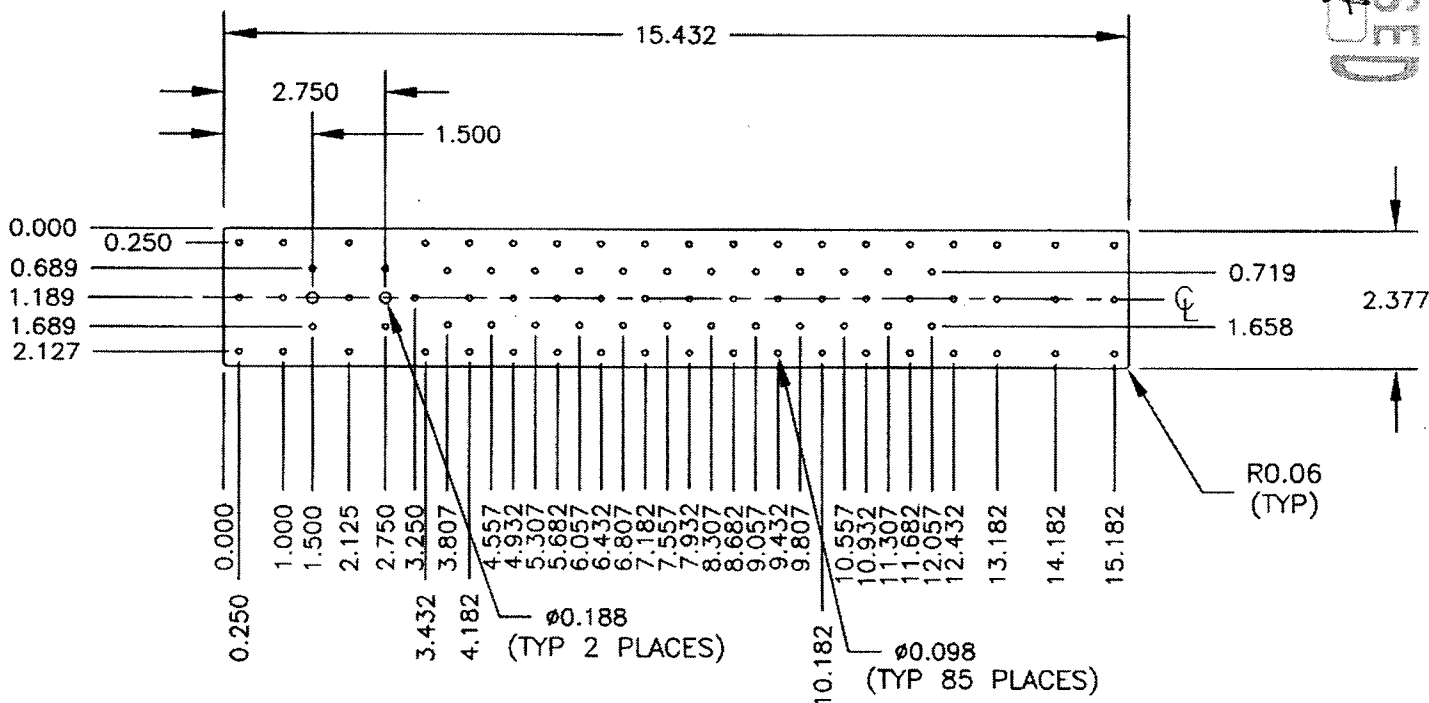
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3283	REV. D
		TITLE	DOUBLER	SHEET 2 OF 2
				SCALE
				1:3

RELEASED  
05-09-06



**D3283-3 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# FIRST ARTICLE INSPECTION CHECKLIST



## First Article



## Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.750	$\pm .010$	14.748	✓			
1.420	$\pm .010$	1.422	✓			
1.250	$\pm .010$	1.250	✓			
1.250	"	1.250	✓			
10.634	"	10.634	✓			
Ø.129	$\begin{matrix} +.005 \\ -.001 \end{matrix}$	.134	✓			
1.500	$\pm .010$	1.499	✓			
3.000	"	2.999	✓			
5.060	"	.060	✓			
.250	"	.250	✓			
.710	"	.710	✓			
1.170	"	1.170	✓			
Ø.500	$\begin{matrix} +.006 \\ -.001 \end{matrix}$	.504	✓			
1.875	$\pm .010$	1.875	✓			
6.192	"	6.192	✓			
2.175	"	2.175	✓			
4.317	"	4.317	✓			

Measured by:	JL
Date:	05.12.21

Audited by:	<i>S</i>
Date:	25/12/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	